

Date: Thursday, 11/12/2008 10:08:00 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 BEARPAW INSTALLATION KIT (48")
Job Number	: 43981		
Estimate Number	: 12283		
P.O. Number	:	Part Number	: D205564011
This Issue	: 11/12/2008 S.O. No. :	Drawing Number	: D2521
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: J
Previous Run	: 43822	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JLD 08.12.11</u>		
Comment	: Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC Est Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: 20 for CL
 08/12/22 Sold 27



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING

Program Batch Number

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 8.4000 sf(s)/Unit Total : 42.0000 sf(s)

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"

(MUHMWB10)

Batch: 110520 B 9-1-19 0

4.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut Blank as per D2521 blank file

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:08:00 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

JL 09/01/26

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/01/26

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 09/01/26

8.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total: 18.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

B39986

B342737

SP

9.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

B342099

20
39238 41
43838

SP

10.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

B38488

80
B42408

9/1/26

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 43981

Part Number: D205564011

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D2947 Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

B36826

B40902

SP

12.0 D3544041 Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

CLAMP

Batch:

B36760

B41905

SP

13.0 AN413A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Batch:

M109959

M109285

SP

14.0 AN415A Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A

Bolt

M108077

M109148

SP

15.0 AN960JD416 Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M108161

M106277

M109249

16.0 MS21042L4 Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Nut

Batch:

M107478

9/1/26

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 09/01/27 (X5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

low C

AS

09/01/27 (X5)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28 (X5)

Job Completion



U 09/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43981
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓			
B	0.90	0.96	.925	✓			
C	0.27	0.330	.310	✓			
D	0.470	0.530	.500	✓			
E	21.740	21.760	21.750	✓			
F	0.72	0.780	.753	✓			
G	0.35	0.410	.381	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.437	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.938	✓			
N	44.47	44.530	44.50	✓			
O	6.590	6.650	6.624	✓			
P	0.940	0.980	.958	✓			
Q	18.97	19.03	19.00	✓			
R	0.350	0.410	.378	✓			
S	0.740	0.780	.751	✓			
T	0.240	0.280	.245	✓			
U	0.370	0.410	.382	✓			
V	0.740	0.780	.743	✓			
W	0.740	0.780	.751	✓			

Measured by:	JL
Date:	09/01/25

Audited by:	JP
Date:	09/01/25

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	



DESIGN	<i>[Signature]</i>	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE	06.07.28			TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

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WORK ORDER
NO. 43981

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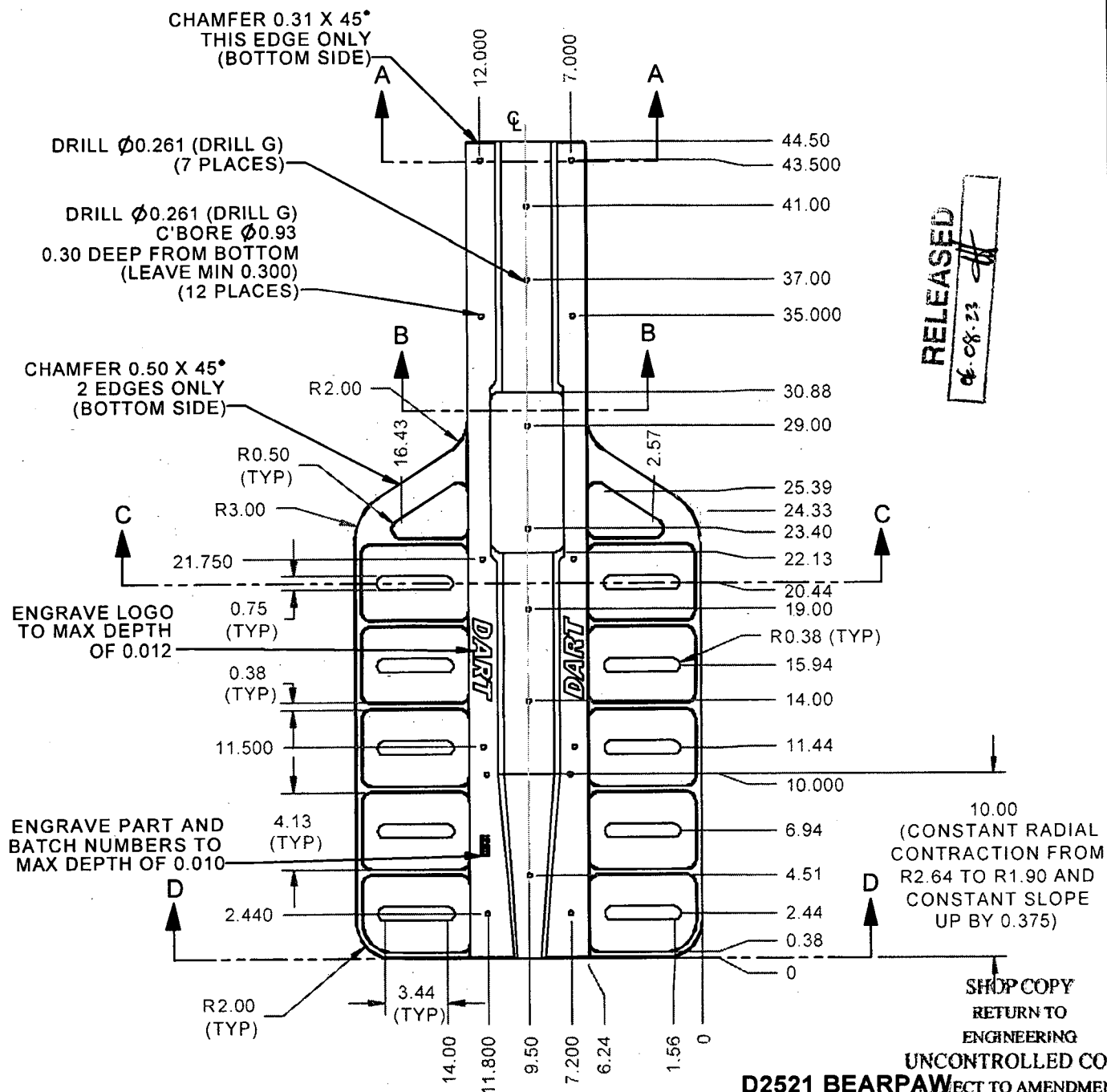
06 08 23 *[Signature]*

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DART

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	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
		D2521	SHEET 2 OF 3
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1:8

**NOTES:**

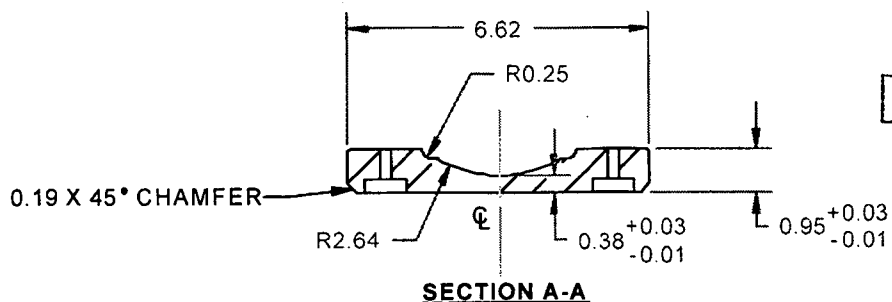
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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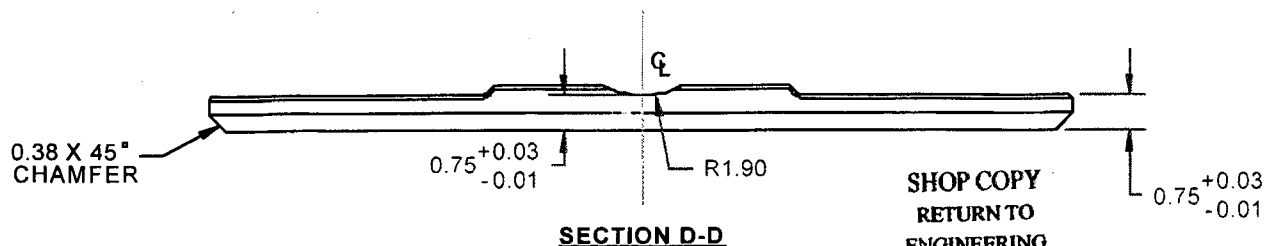
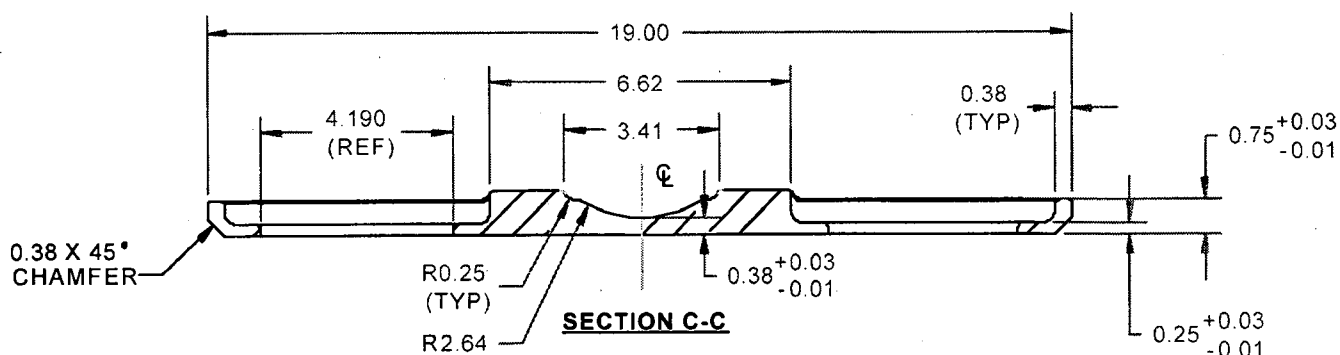
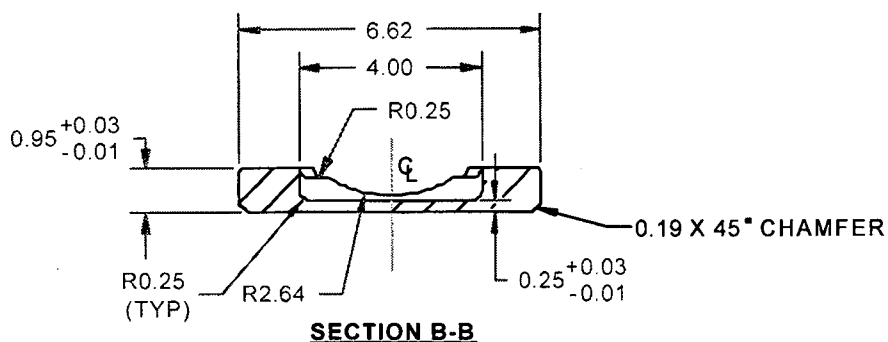


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	



RELEASED

06.08.23 #



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